

Date: Monday, 11/20/2006 11:33:52 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING	
Job Number	: 29545		Part Number	: D26175	
Estimate Number	: 10310		Drawing Number	: D2617 REV D2	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/20/2006 S.O. No. : N/A		Drawing Revision	: D2	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/27/2006	
Previous Run	: 27931		Qty:	30	
Written By	: <u>KJ</u> 06/11/01		Um:	Each	
Checked & Approved By	: <u>KJ</u> 06/11/01				
Comment	: Est H 04/07/14 Rerformat; added step 5 KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W		
		Comment: Qty.: 0.0205 f(s)/Unit Total : 0.2457 f(s) 6061-T6 Round Bar 1.5" Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall M6061T6T0.500W.058) Batch <u>M102765</u>		<u>6/15</u>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL		
		Comment: HARDINGE CNC LATHE SMALL 1-Machine as per Folio FA438 and Dwg D2617 2-Deburr		<u>6/12/01</u> 30
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<u>6/12/01</u> 30
4.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		<u>6/12/01</u> 30
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<u>6/12/01</u> 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/12/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



11/12/04 30

Comment: INSPECT ALODINE

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STS3

11/12/04 30

ST53

8.0 QC21 FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

11/12/04

Job Completion



C Loc 112104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

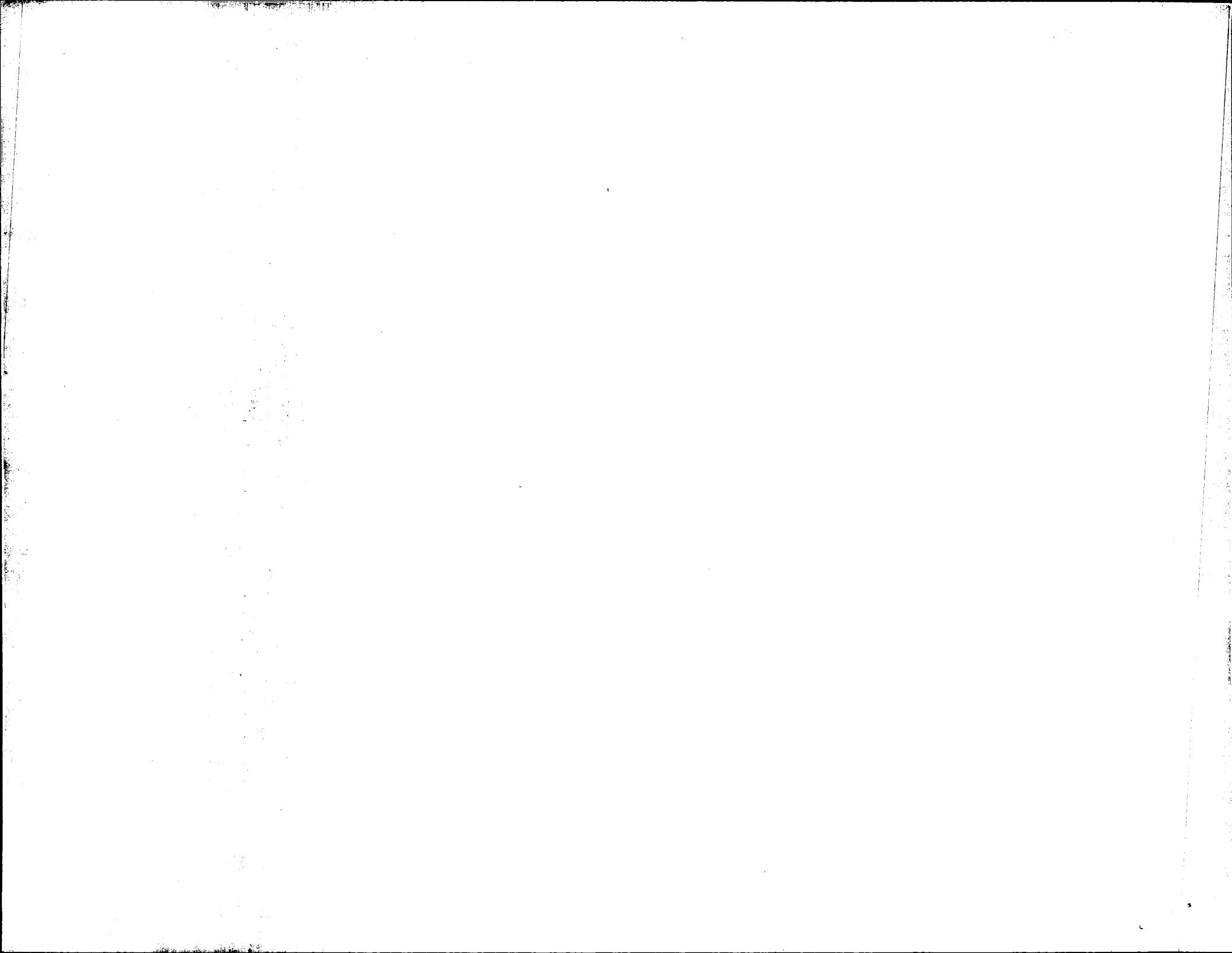
DART AEROSPACE LTD	Work Order:	29545
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617	Rev: D2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>ml</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	06/10/01	Date:	06/12/01	Date:	N/A

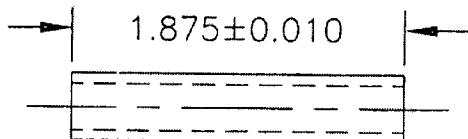
Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	
B	06.03.08	Dwg Rev change	KJ/JLM	



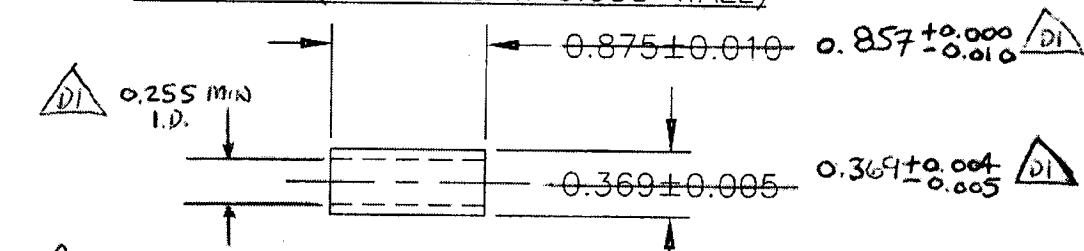


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2617 REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING SCALE 1:1
D2	04.09.10 IP	ADD D2617-7	A	96.10.08 NEW ISSUE
			B	97.05.08 .875 WAS 1.125
			C	97.06.04 0.369 DIA WAS 0.375
			D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
			DI	IP-# 04.07.12 CORRECT TOLERANCE (NCR 779)

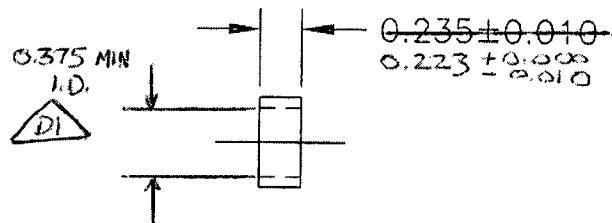
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 ~~IP~~

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29545

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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